

Friday, July 22, 2016 2:45:10 PM

AMOD Page 1

Page 1

Accept

N900040100

Setup · Start ***NS1***

Stop *NS2*

Item Name: Arm

Start Date: 9/6/2016 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 9/15/2016 **Req'd Qty:** 8.00

g

Customer:

Reference:

Approvals: Process Plan: dm

Date: 16/07/25

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

Work Order ID 149437

Friday, July 22, 2016 2:45:10 PM

149437

Page 2

Item ID: D3560-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 9/6/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 9/15/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				8	φ		DAS 49 9-89
130									16/08/16
QC	Memo	0.03							
Quality Control									
210	Identify as per dwg & Stock Location: _____	0.00							AUG 16 2016
210									
Packaging	Memo	0.01							DAS 6 9-89
Packaging	LOCATION: WA003								
220	QC21- Final Inspection - Work Order Release	0.00							
220									DAS 21 9-89
QC	Memo	0.13							AUG 17 2016
Quality Control									

DAS
21
9-89
AUG 17 2016

Picklist Print

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Page 1

Work Order ID: 149437

149437

Parent Item: D3560-2

D3560-2

Parent Item Name: Arm

Start Date: 9/6/2016

Required Date: 9/15/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-11-10 JLM use -042
13.06.03 PER DWG REV.F DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.500X05.00
0

Purchased

No

f

29.9890

11.74737

DAS

44

9-89

M6061T6B0 500X05 000

16-08-14

6061-T6 Bar .500 x 5.00

Location

Loc Qty

Loc Code

MAT

3.497

m134514

0.667

nm134533

2.83

MAT001

26.492

m130527

1.545

m131392

0.947

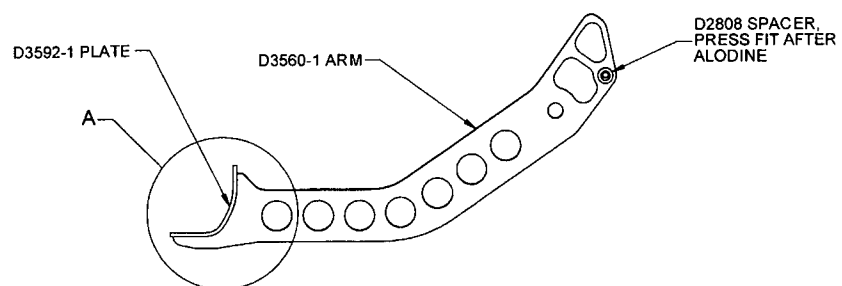
m134984

24

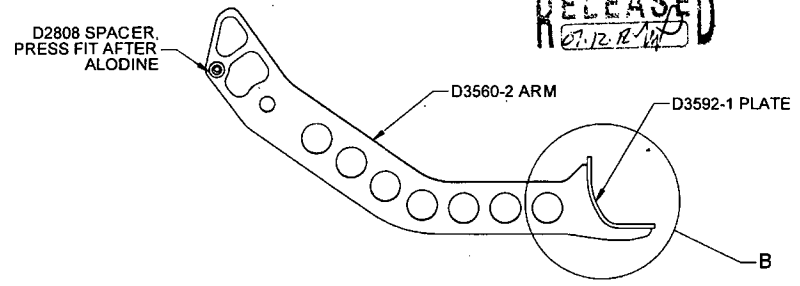
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11.75

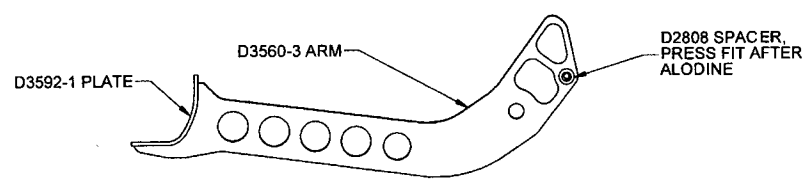
RELEASED
07.12.16



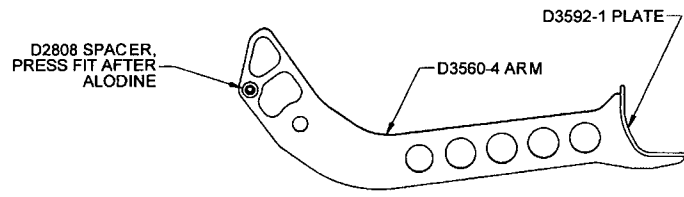
D3560-041 ARM WELDMENT



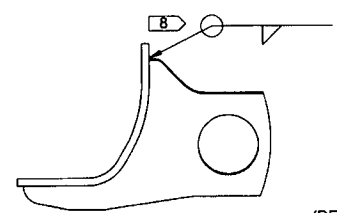
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



**DETAIL A
SCALE 1 : 2**

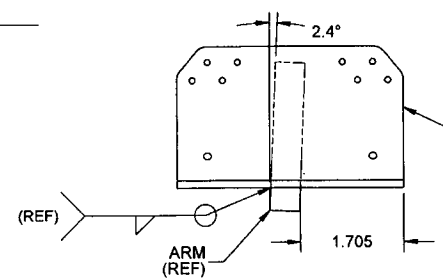
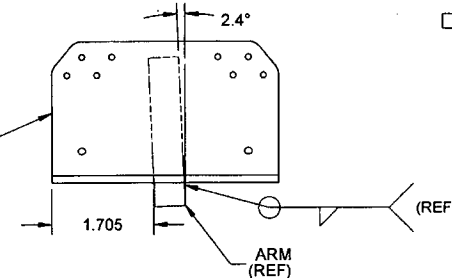


PLATE (REF)



**DETAIL B
SCALE 1 : 2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

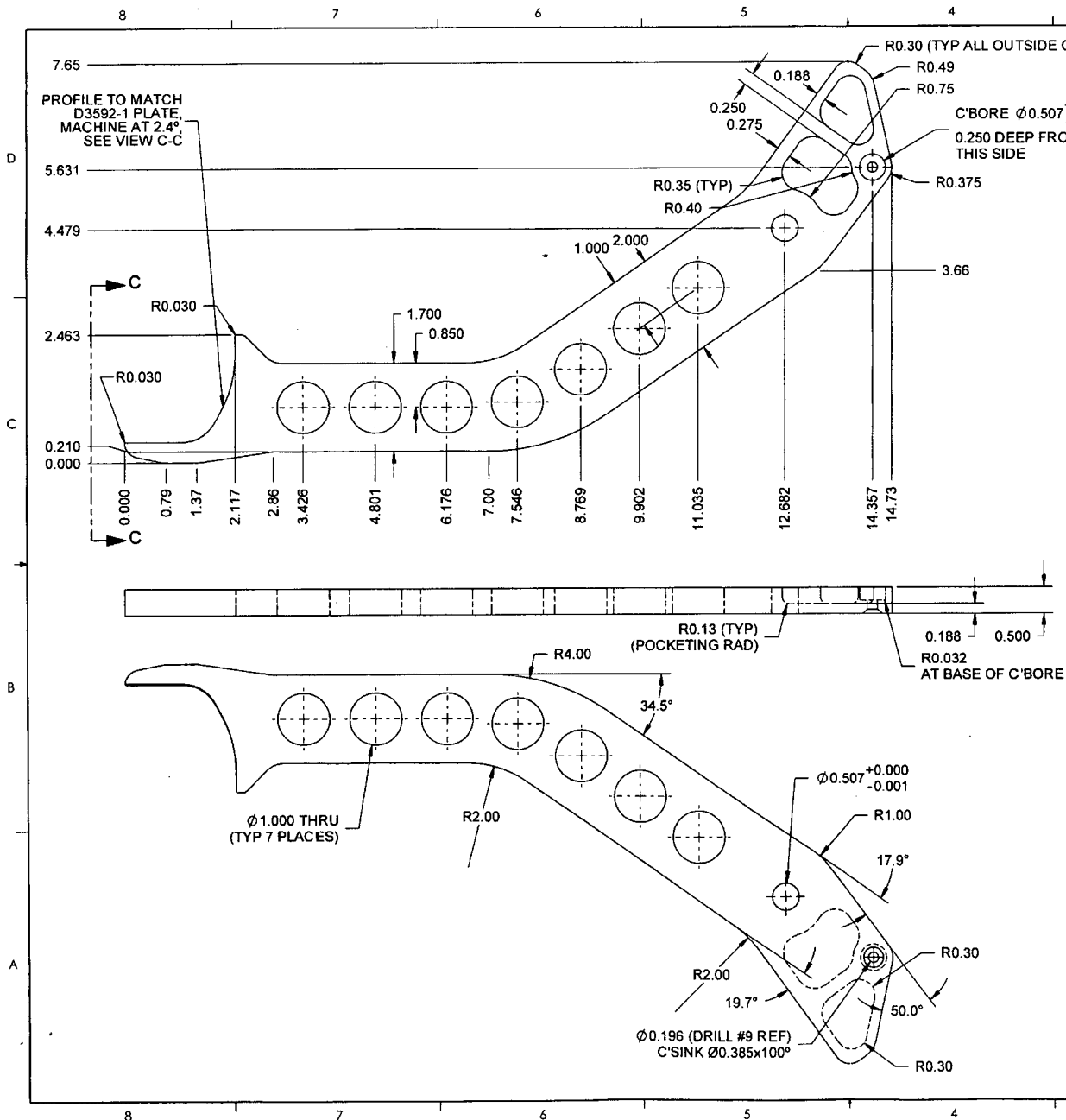
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3560	REV. D
TITLE ARM WELDMENT	SHEET 1 OF 5
SCALE 1:4	
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w/o 149437

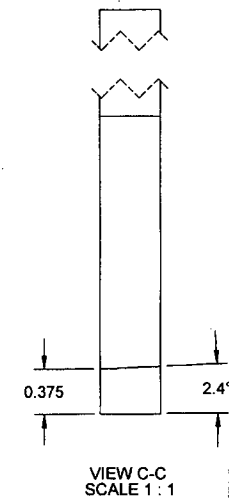
dem 16/07/25



D3560-1 ARM WELDMENT

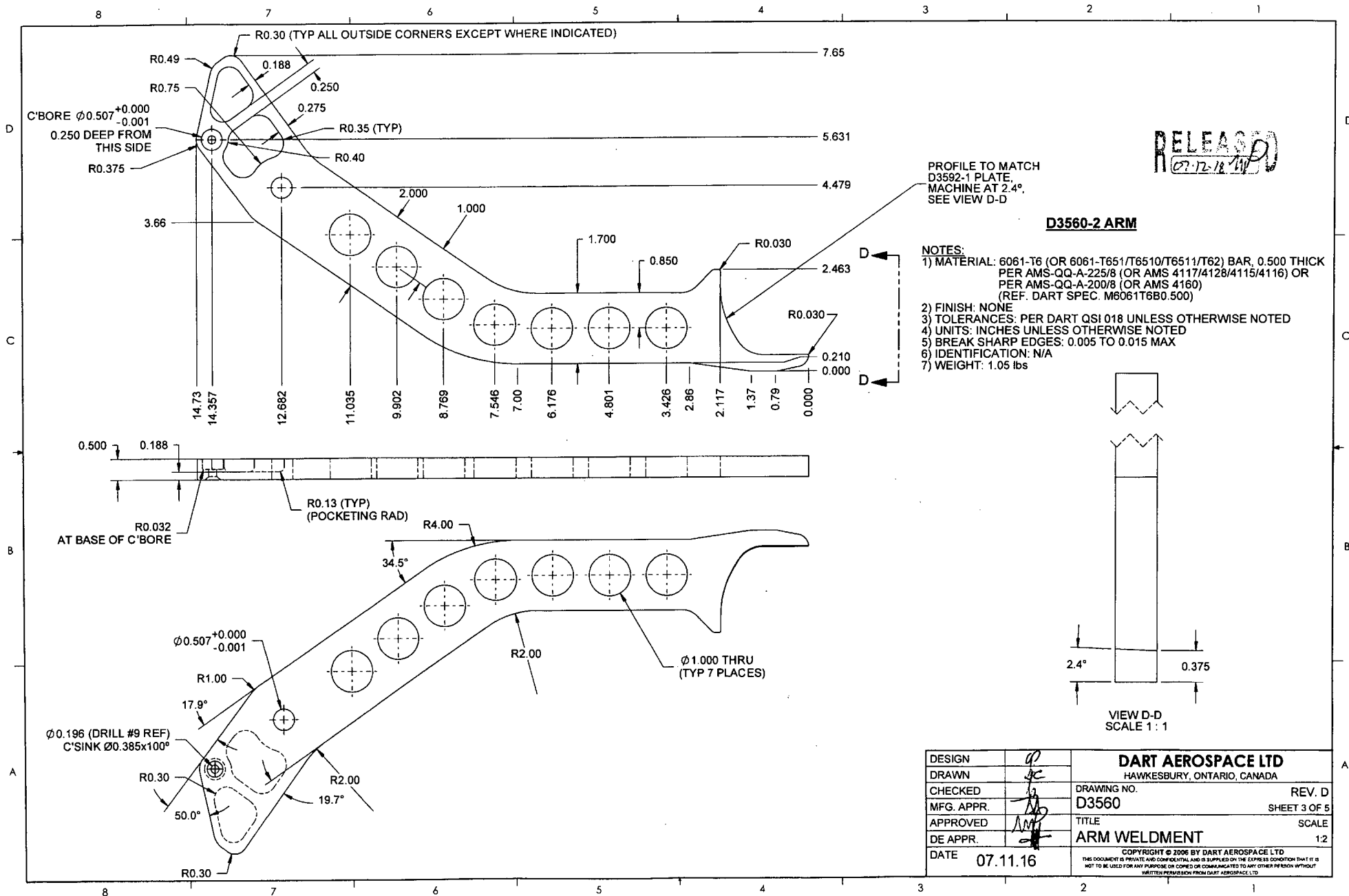
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



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07.12.16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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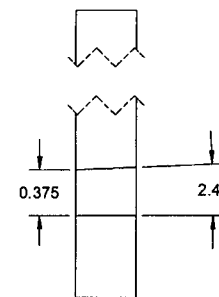


PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°
SEE VIEW E-E

D3560-3 ARM

NOTES:

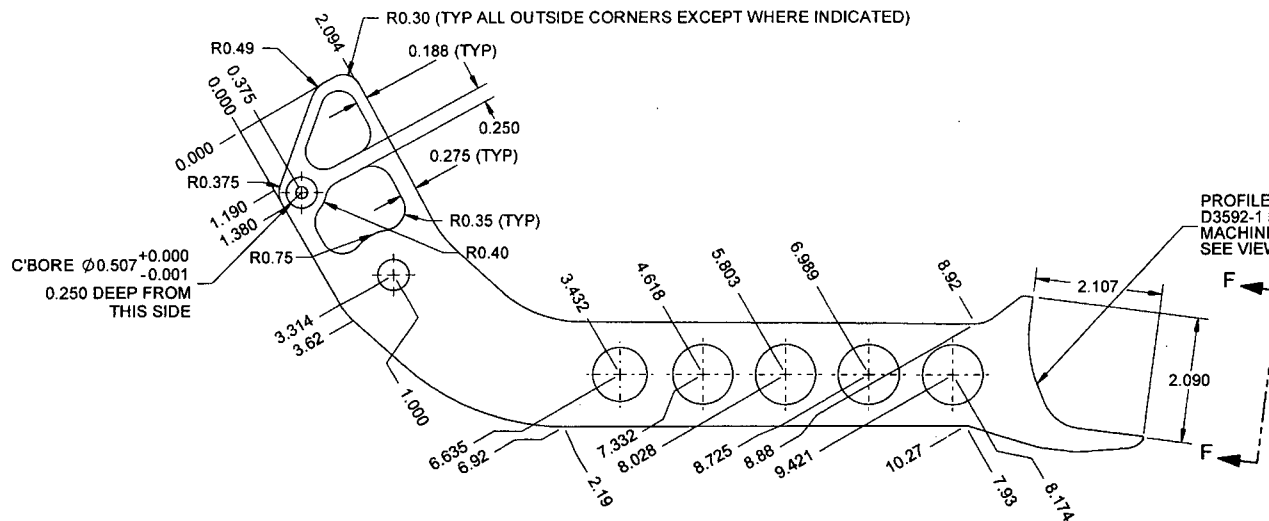
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW E-E
SCALE 1:1

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07.12.14

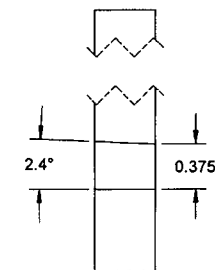
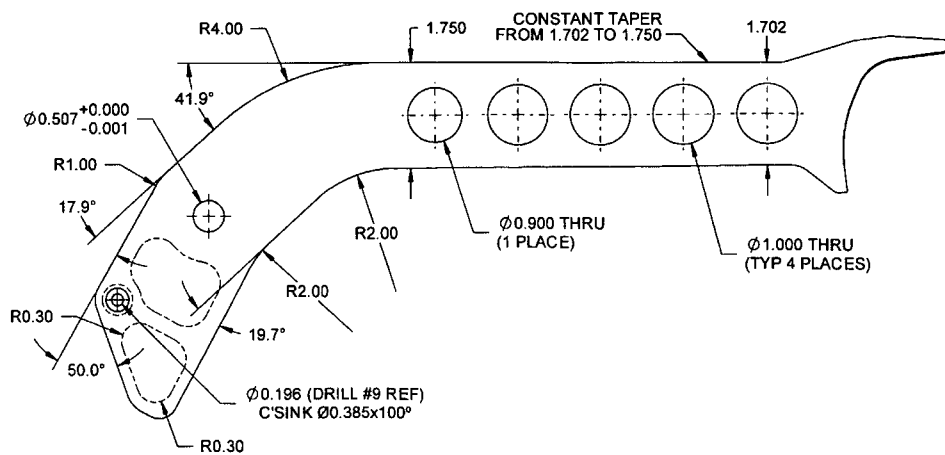
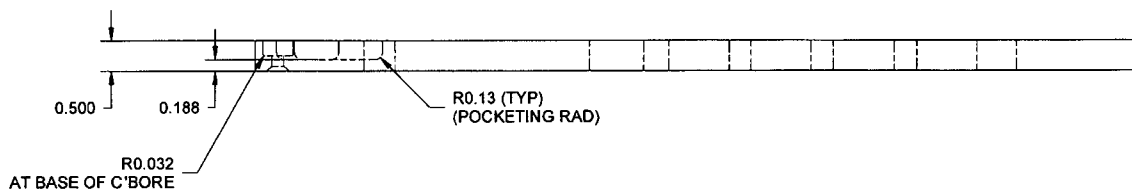
DESIGN	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AC		
CHECKED	AC	DRAWING NO. D3560	REV. D
MFG. APPR.	AC	SHEET 4 OF 5	
APPROVED	AC	TITLE ARM WELDMENT	SCALE 1:2
DE APPR.	AC	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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D3560-4 ARM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

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07-11-16

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DRAWN	PC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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